

Audit Review and Evaluations OF

JEMISON METALS

**188 Enterprise Dr,
Madison Heights, VA 24572**

Dates of Audit: 10/24/2024
Date of Submittal: 10/28/2024

Auditor: Nathan Ragland – Quality Management Coordinator

1.0 Summary

This internal audit review provided an evaluation of Jemison's current level of conformance to the ISO 9001:2015, against the current internal audit schedule. The audit measured how effectively the quality management system is implemented in conformance with the applicable requirements and standards. **Based upon our review, the QMS is effectively implemented.**

Audit Detail/Observations/Findings

7.5 – Documented Information

The following forms and documents were verified during the audit: LYN-RC-001 Receiving Procedure Rev. 2 (Quality Intranet-No Hard Copy Present), LYN-PB-001 Press Brake Procedure Rev. 2 (Quality Intranet-No Hard Copy Present), LYN-FAB-001 Rev. 3 Fabrication FP Inspection Procedure (Quality Intranet-No Hard Copy Present), LYN-LA-001 Laser Procedure Rev. 3 (Quality Intranet-No Hard Copy Present), LYN-LRB-001 Redbud Procedure Rev. 1 (Quality Intranet-No Hard Copy Present), JDM200 Quality Policy Rev. 1, GAD059 Rev. 0 Press Brake check sheet, LYN-F-001 Rev. 1 CTL QA form.

7 Support

Employees appeared competent and well trained. Adequate resources (gauges, safety equipment, operating equipment, and environment) were observed during the audit.

7.2 Competence

Reviewed Training Status Matrix:

Confirmed training status:

William Bersch, Punch combo - Trained

Vincent Coles, Press Brake-In Training

Nick Torrents, Red Bud Operator-Trained-Trainer

Frank Simms, Receiving - Trained, Shipping -Trainer

Noel Regio, Shipping - Trained

8.2 Requirements for products and services

Nordfab purchase order 8025994-1 due 8/13/2024

Received by Paula Loveless 8/7/2024

Confirmation email sent 8/7/2024

S/O 40646-1 entered 8/7/2024

Order filled 8/13/2024

8.4 Control of externally provided processes, products and services.

Mill Coil #2701084 from ArcelorMittal received off PO LYN 6477-1. Receiver 13715 dated 10/24/2024. Bucket CRC DSENT1 18 53.24” met all requirements for customer parts in that bucket. Receiver stamped and signed.

8.5-Production & Service Provisions

Receiving:

B/L CLPPEU224AWSA207 (PO LYN 6573) Receiving paperwork stamped, filled in, signed and dated. Receiver – Frank Simms

Shipping:

B/L 33994 S/O LYN 41549-3,5,6,8,12,13,14 ABB shipped 10/24/2024. All tags were matched, and all material was shipped and checked off. Bill of Lading signed and dated in all appropriate spots. Shipper – Noel Regio

Production:

Punch: W/O LYN 37619, ACS part W067B1763 floor stock job. All checks performed (Jem Print) and documented by operator William Bersch, met all requirements of Procedure LYN-PC-001. The operator displayed proficiency and ability to locate procedures. (OBS #1 – Operator did not include part number on GAD059)

Press Brake: W/O 37717 HP Fab part F899801GGL floor stock job, documentation reviewed Controlled Document GAD059 filled in correctly. Sampling check frequency met all requirements of Procedure LYN-PB-001. Operator: Vincent Coles (OBS #2 – Operator needed assistance locating procedures in FIT).

Red Bud: W/O LYN 37521 ABB parts 1LBU003070A0003 and 1LBU00370A0010 to fulfill S/O 41549-4,5. All checks performed and documented on LYN-F-001 by operator Nick Torrents per procedure LYN-LRB-00. The operator displayed proficiency and ability to locate procedures.

Laser: W/O 37718 HP Fab part WF866979AGL floor stock job. All checks performed and documented on Jem print and GAD059 by operator T’Juan Jones, met all requirements of Procedure LYN-LA-001. The operator displayed proficiency and ability to locate procedures.

7.1.3 Infrastructure

Preventive Maintenance: Reviewed with Bill Huffman and Daniel Goff. Monthly PM schedule and status for September internal preventative maintenance reviewed. All scheduled maintenance documented as performed for September. All documents initialed, dated, and approved.

7.1.5 Monitoring and Measuring Resources

The following gauges were verified to be calibrated in compliance with calibration records:

Measuring Equipment:

Micrometer 036, due 10/31/2024

Micrometer 044, due 10/31/2024

Micrometer 03, due 10/31/2024

Protractor 48, due 10/31/2024

Caliper 1, due 10/31/2024

Caliper 2, due 10/31/2024

Caliper LB-1, due 10/31/2024

Tapeline 01, due 1/31/2025

Tapeline 04, due 1/31/2025

Step Gage ST-9, due 2/28/2025

Measuring Standards:

Gage Block 232126, due 9/15/2028

Gage Block 237137, due 9/13/2028

Gage Block 220153, due 2/8/2028

Romer Arm, due 1/31/2027

8.7 Control of Nonconforming Product

The nonconforming area was well defined and neat.

Tags:

202061 in LSC warehouse.

201116 in LSC warehouse.

83482 in LSC warehouse.

82987 in LSC warehouse.

10.2 Nonconformity and Corrective Action

Open Corrective Actions:

26918 entered 07/23/2024. All audits performed and met the requirements. CA to be sent to Rick Rowland for review and closure.

Corrective Actions closed since the last audit:

25744, Continuous Improvement entered 10/2/2023. All audits performed and met the requirements.

26375 entered 2/23/2024. All audits performed and met the requirements.

26481, minor finding from previous audit, entered 8/24/2023. All audits performed and met the requirements.

10. Improvement

1) New 25-ton crane installed in center bay to allow full truckload sized masters to be shipped to LYN and improve efficiency of Red Bud processing.

- 2) Gold samples have been created for Punch/Fiber Combo parts to ensure correct tooling is being used.
- 3) Full implementation of GAD059 on Punch/Fiber Combo so operators can document periodic checks.
- 4) Monitor displaying real-time quality and production KPI charts.

Observations and findings from previous audit:

Minor 1 – No legible ID marking on measuring tool. Corrected prior to end of audit.

[Corrective Action 26481 was created and completed. Routine checks for ID legibility performed.](#)

2.0 Overview

2.1 Personnel Interviewed (Audit evidence found in the Audit Worksheets)

Vincent Coles-Press Brake Operator	Nick Torrents-Red Bud Operator
William Berch-Punch/Fiber Combo Operator	Paula Loveless-Inside Sales
T’Juan Jones-Laser Operator	Bill Huffman-Plant Manager
Frank Simms-Receiver	Noel Regio–Shipper Trainee
Daniel Goff-Maintenance	

2.2 Audited Requirements

<p>4 Context of the Organization</p> <p>4.4 Quality Management System and its processes</p> <p>5 Leadership</p> <p>5.1 Leadership and commitment</p> <p>5.1.2 Customer Focus</p> <p>5.2 Policy</p> <p>5.6 Management review</p> <p>6 Planning</p> <p>7 Support</p> <p>7.1.1 General</p> <p>7.2 Competence</p> <p>7.1.3 Infrastructure</p> <p>7.1.4 Environment for the operation of processes</p> <p>7.1.5 Monitoring and measuring resources</p> <p>7.5 Documented information</p>	<p>8 Operation</p> <p>8.1 Operational planning and control</p> <p>8.2 Requirements for products and services</p> <p>8.3 Design and development of products and services (N/A)</p> <p>8.4 Control of externally provided processes, products and services</p> <p>8.5 Production and service provision</p> <p>8.7 Control of nonconforming outputs</p> <p>9 Performance evaluation</p> <p>9.1 Monitoring, measurement, analysis and evaluation</p> <p>9.1.1 General</p> <p>9.1.3 Analysis and evaluation</p> <p>10 Improvement</p> <p>10.2 Nonconformity and corrective action</p>
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2.3 APPROVAL/SIGN-OFF

Report Prepared by Nathan Ragland

Date 10/24/2024

Nonconforming Corrective Action Report (CAR) for Jemison
Metals

CAR #	ISO 9001: 2015 Clause / Sub-Clause	Findings/Requirements	Observati on	Mino r	Major
NA	8.5.2	Operator did not include part number on GAD059	1		
NA	7.2	Operator needed assistance to locate procedures in FIT	1		